

Date: Tuesday, 4/18/2006 9:58:37 AM
 User: Kim Johnston

Process Sheet

SB 06/06/12

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
 Job Number : 26646
 Estimate Number : 10336
 P.O. Number : N/A Part Number : D2807
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D2807 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : 25247 Material : N/A
 Due Date : 5/5/2006 Qty: 50 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.04.18
 Comment : Est: D 05.06.21 Removed painting; Changed supplier
 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1035

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

C206104119

(50)

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

06/06/12

(50)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.06.12 (50)

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

2 D2807-3 Lug Batch:

526625 (26) B27152

(46)

B26757 (26)

B26447-B (47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 9:58:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 26646

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

SAB

06-06-13

38

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAB

06/06/13

38

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST387

AS

06/06/13

38

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/14

38

Job Completion



06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

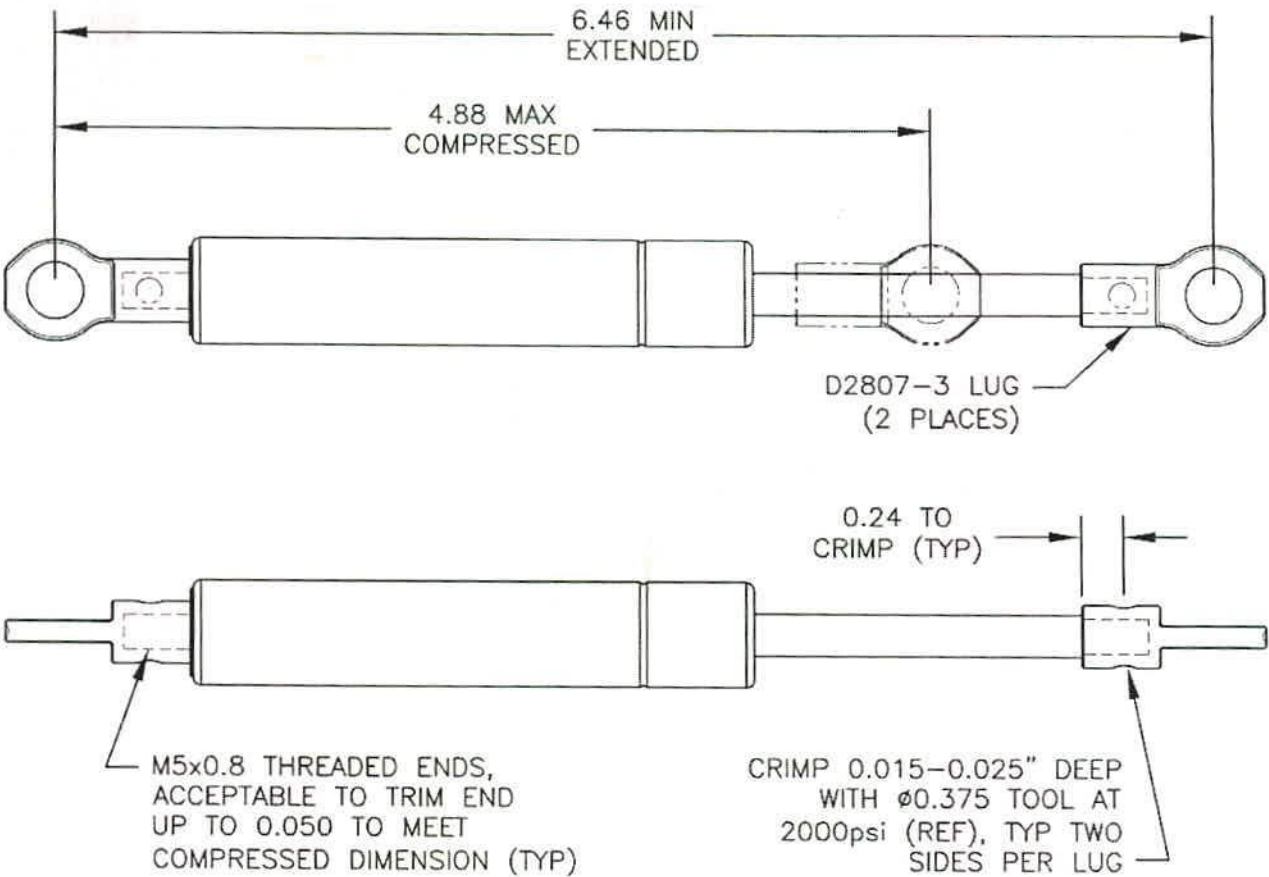
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
#5-06-16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE		TITLE
05.05.25		GAS SPRING
		SCALE
		1:1
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG

**D2807 GAS SPRING**

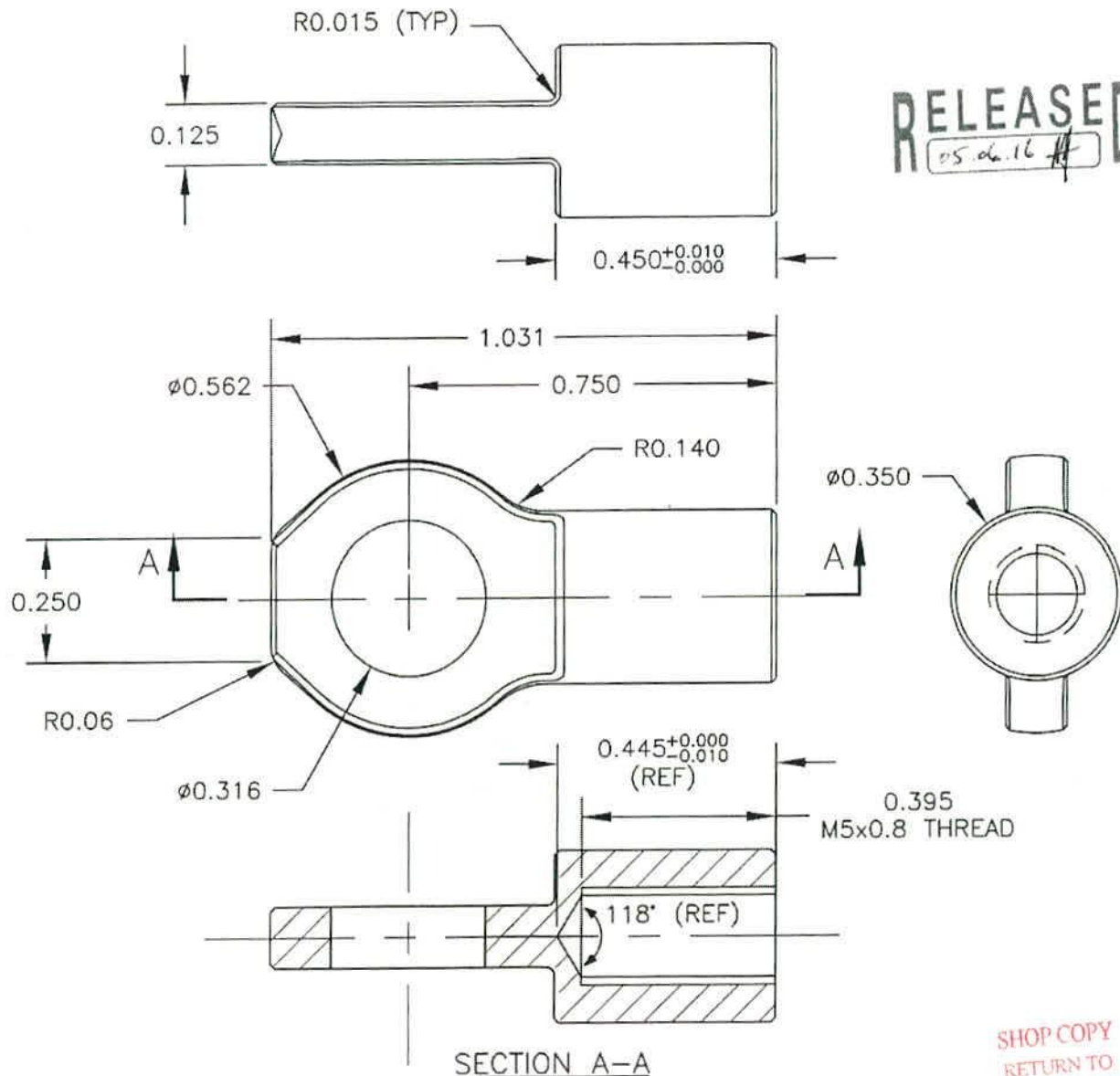
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26646

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD
SHIP WITH AE: 57561 VIA
FEDEX P-1 OVERNIGHT SVCE
ACCOUNT NO: 15179324-0

20111

46

CUSTOMER REF. No.

P000001035

V.A.T. REGISTRATION No. GB 738 8577 71

[illegible]

Cam 001

Website: www.camloc.com

FED EX
8490 2198 6376

YOUR ORDER WAS PACKED BY

YOUR ORDER WAS PACKED BY
 Certified that the whole of the supplies detailed hereon
 have been inspected and tested and unless otherwise stated
 conform in all respects with the contract/purchase order
 requirements.

SIGNED

POSITION

